

# Work Order ID 56671

March 4, 2010 11:19:19 AM



Page 1

Item ID: D4064-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Lug

Start Date: 3/04/10 Start Qty: 10.00



Cust Item ID:

Required Date: 3/12/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4064

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per Dwg

DWG REV: *A*

PROG REV: *1*

DEBURR IF REQUIRED

*B 10-3-0*

*(15)*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control



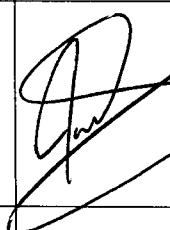
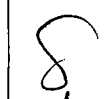
*B 10-3-0*

*(10)*

*P10 =>*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4064-041 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes (No) DQA: / Date: 1004-08  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>56671</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.03.30	130	PIN NOT ENGRAVED QC Parts were made in Manuel	 10.03.30 per QS1 042	Acceptable.	 n/a	 10.03.30 per QS1 042	 10.03.30	

NOTE: Date & initial all entries

**Work Order ID 56671**

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Item ID: D4064-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Mounting Lug

Start Date: 3/04/10 Start Qty: 10.00

Cust Item ID:

Required Date: 3/12/10 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

0.00



Mill Conv

Memo

0.00

Conventional Milling Machine

MILL RADS, DRILL HOLES AS PER DWG  
GRIND RAD .060"-.100" BY HAND

SL 10/03/11

140

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

SL 10/03/11

150

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

Jm/10-03-11

(10) ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 56671**

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Page 3

Item ID: D4064-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Lug

Start Date: 3/04/10 Start Qty: 10.00



Cust Item ID:

Required Date: 3/12/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

13K 10-3-15 (10)

170

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

M113170  
START: 8:00AM  
Temp: 320°F  
Fin: 8:30AM

=&gt; 10/01/30 (10) /

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

S 01/03/30

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 56671**

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Page 4

Item ID: D4064-041

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Revision ID:

Item Name: Mounting Lug

Start Date: 3/04/10 Start Qty: 10.00

Required Date: 3/12/10 Req'd Qty: 10.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

0.00



HandFinish

Memo

0.00

Hand Finishing

ASSEMBLE GROMMETS AS PER DWG

Ep 10/03/30 10

200

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

8.10.03/30

10

210

0.00



Packaging

Identify as per dwg &amp; Stock Location: ST 464

Memo

0.00

Packaging

CZ 10/3/31 10

# Picklist Print

March 4, 2010 11:19:19 AM

Page 1

Work Order ID: 56671

Parent Item: D4064-041

Parent Item Name: Mounting Lug

Comments: IPP REV:A NEW ISSUE 10-03-01 JLM VERIFIED BY:EC

Start Date: 3/04/10

Required Date: 3/12/10

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B0.750X06.00 0		Purchased	No			100	f	63.5488	3.6842	5.6		



6061T6 BAR .750 X 6.00



10-3-8

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
MAT	63.5488	
110912	3.5488	
112567	60	
MS35489-93		
Purchased	No	
	190	Each
	26.0000	20.0000



GROMMET

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	26	
113368	26	

15

112567

950/03/30  
M114108 (20x)



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

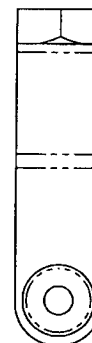
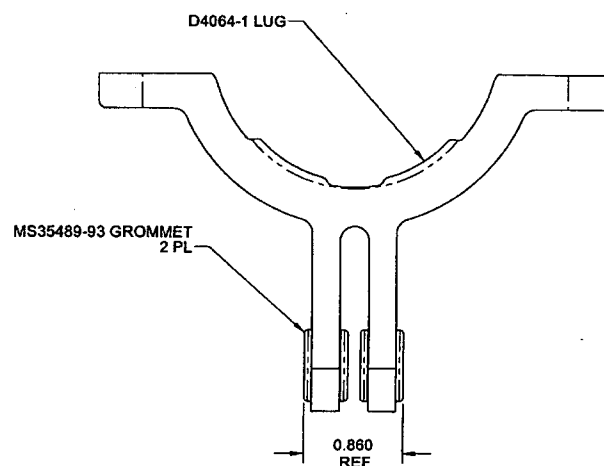
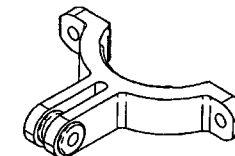
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



ITEM	QTY	P/N	DESCRIPTION
1	X	D4064-041	LUG ASSEMBLY
2	1	D4064-1	LUG
3	2	MS35489-93	GROMMET

1056671



**D4064-041 LUG**

**RELEASED**  
2010-03-01

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.18 lbs

REV.	NEW ISSUE	DESCRIPTION	CP	DATE
DESIGN			BY	DATE
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	10.01.25			

**DART AEROSPACE USA, INC.**  
PORT HADLOCK, WA  
REV. A  
SHEET 1 OF 2  
SCALE  
NTS  
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ulb  
56671



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MFG. APPR.	<i>JP</i>		NTS
APPROVED	<i>JP</i>		
DE APPR.	<i>JP</i>		
DATE	10.01.25		